

NCR-19-7701

5162119



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2620

Job Sheet 191437-A



Part No: D2620

Job Qty: 1 pcs

Part Name: Skidtube, 206 Skidtube



Part Weight: 0 lbs

Job Created: 3/13/19

Due Date: 3/1/19

Type: Stock

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	1 pcs	3/1/19	3/1/19	0.00	0.26	Skidtubes - Bend	1.00	
110	QC 5	1 pcs	3/1/19	3/1/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	3/1/19	3/1/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		



Container No: S162119



Part: D2620

Job No: 191437 - A

Serial No/Batch: S157984

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/13/19

Dart Aerospace Ltd.
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CANADA
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					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	MAG
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
130	QC 21 - SA	1 pcs	3/1/19	0.00 0.00	QC 21 - SA - 21	DAE
					QC 21 - SA - 70	21
					QC 21 - SA - 53	21

Part Op 100 - Skid tubes - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2-
 Descriptions: Cut Fwd end of tube as per Dwg D2620
 110 - QC5- Inspect part completeness to step on W/O)
 120 - Identify as per dwg & Stock Location: _____ LOCATION : LG002
 130 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-1-160	Extrusion Round 3" 206	1 pcs (1 ea)	100-Skid tubes - Bend - 1	B141287

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Skid tubes - Bend - 1	D2600-1-160	1	20	0

Part Specifications	
Specifications could not be found.	

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Tel (613) 632-5200
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D2620

Job Sheet 191437



Part No: D2620

Job Qty: 4 pcs

Part Name: Skidtube, 206 Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/28/19

Job Tracking No:

Due Date: 3/1/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	4 pcs	3/1/19	3/1/19	0.00	1.05	Skidtubes - Bend		MGC
110	QC 5	4 pcs	3/1/19	3/1/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Packaging 3-1 - Stock - B4B	4 pcs	3/1/19	3/1/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		



Container No: S157984



Part: D2620

Job No: 191437

Serial No/Batch: S157984

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/01/19

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				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
				Packaging 3 - 17 - B4B			
				Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
130 QC 21 - SA	4 pcs	3/1/19	0.00 0.00	QC 21 - SA - 21			
				QC 21 - SA - 70			
				QC 21 - SA - 53			
Part Op 100 - Skid tubes - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Follo Ft008 2- Descriptions: Cut Fwd end of tube as per Dwg D2620 110 - QC5- Inspect part completeness to step on W/O) 120 - Identify as per dwg & Stock Location: _____ LOCATION : LG002 130 - QC21- Final Inspection - Work Order Release							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
D2600-1-160	Extrusion Round 3" 206	4 pcs (1 ea)	100-Skid tubes - Bend - 1	B24/287			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-Skid tubes - Bend - 1	D2600-1-160	4	24	0			
Part Specifications							
Specifications could not be found.							

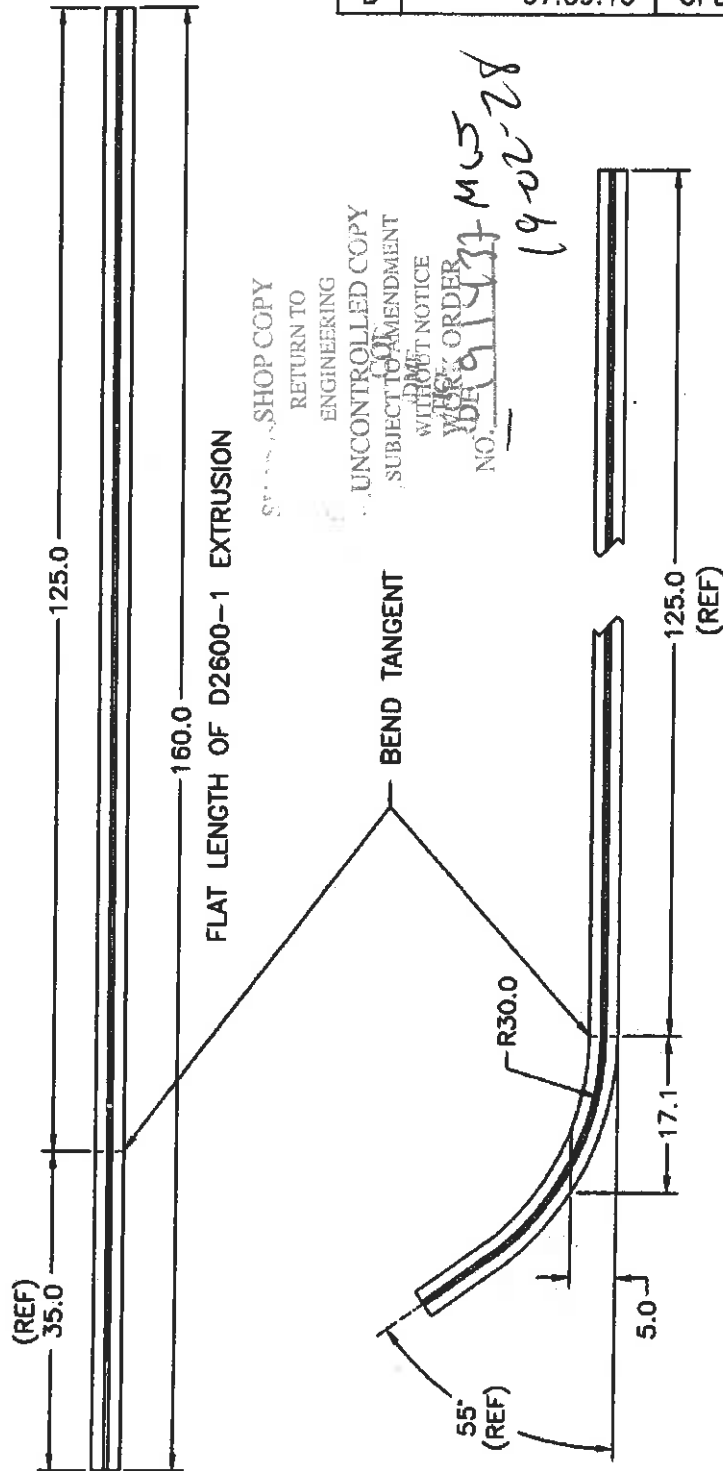
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DART



DESIGN <i>[Signature]</i>	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2620	REV. B SHEET 1 OF 1
DATE 99.09.10		TITLE 206 SKIDTUBE BENDING CONTROL	SCALE 1:20
A	97.11.07	NEW ISSUE	
B	97.09.10	UPDATE FOR IN-HOUSE BENDING	

SPECIFICATION CONTROL DRAWING 206 SKIDTUBE BENDING



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19-02-28

RELEASED
99.09.15 DS

- DAMAGE TOLERANCE**
1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
 2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
 3. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
 4. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
 5. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
 6. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
 7. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

Entered: JK Date: Nov 8/19



NCR No. 19-7701

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>191437-1</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>D2620</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☒ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>19-11-05</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>				MRB (QSI042)			
Description Work Order Deviation				Disposition				N.O. 19-11-05			
Tube was not trimmed qty(1)				This tube will be used for SOS prototype, to be trimmed on job 191934 for D5634-041-Bent 191950				Completed By <u>JW</u> 19-11-05			
								Lead hand / Supervisor <u>JW</u> 19-11-05			
								QC / QA Coordinator <u>DAS</u> 9-89 19-11-05			
Root Cause		FAULT CATEGORY									
Operator ☐		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong			
Manufacturing Process ☐		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☒ Outside Tolerance			
Equip/Tooling ☐		☐ Crushing		☐ BOM/Route		☐ Grain Direction		☐ Drawing			
Handling/Presservation ☐		☐ Cracks		☐ Broken/Damage/Defect		☐ Weld		☐ Finish			
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing			
Product Improvement ☒		☐ Marks/Chatter		☐ Drill Holes		☐ Out of Sequence		☐ Misread			
Process Improvement ☐		☐ Mislabeled		☐ Fit/Function		☐ Off-set/Set-up					
Human Factors ☐		Other/Details:									